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D119-755-014
Job Sheet 188773



Part No: D119-755-014

Job Qty: 2 pcs

Part Name: Bubble Window - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 2/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A New Issue 6/28/2007 DL IPP B Dwg. Update 4/25/2008 DL verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		2/12/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		
							Packaging 1 - 32		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date : _____		Sequence #: _____		QTY Affected : _____	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120	QC 4	2 pcs	2/12/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
125	DC - 1 - B4B	2 pcs	2/12/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
130	Packaging 3-1 - Stock - B4B	2 pcs	2/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
140	QC 21 - FG	2 pcs	2/12/19	0.00 0.00	QC 21 - FG - 21	

Part Op 120 - (QC4- 100% Inspect kits for completeness)

Descriptions: 125 - Photocopy bluefile & type labels per PPP 119-755-014 CHG 001

130 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D119-755-014 Location : FG104

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2126	Locking Seal (Sold Per Foot)	14.1666 ft (7.0833 ea)	110-Packaging 1 - Pick Kit	5107093
D3561-1	Seal Insert Tool	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5957269

9-89

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D2126	14	448	0
	D3561-1	2	9	0
	D3624-2	2	2	0

Part Specifications

Specifications could not be found.

Plex 1/15/19 11:46 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S147339



Part: D119-755-014

Job No: 188773

Serial No/Batch: S147339

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH07-36 Issue 2 of 2
FAA STC SR025081Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) ☐	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

52.4 Re-Installation of D119-755-014 Bubble Window Kit

- 52.4.1 At the customer's option, remove RH crew door (109-0360-01-164 or equivalent) from the aircraft per the Aircraft Maintenance Manual to facilitate window installation.
- 52.4.2 Remove any existing window per the Aircraft Maintenance Manual or applicable instructions.
- 52.4.3 Install the D3624-2 Bubble Window in the doorframe using D2126-0850 Seal as shown in Figure 52-1. Before actually installing the window, verify that there is at least 0.30" (7.6mm) of overlap between the window and the door frame along the straight edges of the window and at least 0.12" (3.0mm) of overlap along the radius of the corners. The recommended procedure is to install the seal onto the door and then to install the window into the seal. Trim the ends of the seal as required. Seal ends should meet at the 6 o'clock position with a maximum gap of 0.125" (3.2mm). If a gap exists, it should be filled with Proseal or PRC. The included D3561-1 Seal Insert Tool can be used to assist in working the seal around the window. If necessary, it is acceptable to trim the window to improve the fit as long as the minimum overlap values are maintained.
- 52.4.4 If the crew door was previously removed, re-install modified crew door on the aircraft per the Aircraft Maintenance Manual.
- 52.4.5 Verify proper closing, sealing, and latching of the door.
- 52.4.6 Note: To increase downward viewing clarity, it is acceptable to cut a small section from the bubble window on its downward side. The cut-out can be a maximum of 5.25" wide x 13.50" long (133mm x 343mm), measured along the profile of the bubble window. The corners of the cut-out must have a minimum radius of 2" (50mm). The cut-out should be located within 1.0" to 1.5" (25mm to 38mm) of the bubble flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 52-2 for reference.

52.5 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-755-011 Crew Door Window Kit, LH / RH	3.5 lb 1.6 kg	±27.6 in ±0.70 m	±97 in-lb ±1.12 m-kG	63 in 1.60 m	220 in-lb 2.6 m-kG
D119-755-014 Bubble Window Kit, RH	4.5 lb 2.0 kg	+31.6 in +0.80 m	+142 in-lb +1.60 m-kG	63 in 1.60 m	284 in-lb 2.6 m-kG

52.6 PARTS LIST

Qty -011	Qty -014	Part Number	Description
X		D119-755-011	CREW DOOR WINDOW KIT (FITS LH & RH)
	X	D119-755-014	BUBBLE WINDOW KIT, RH
1	1	D2126-0850	SEAL
1		D3623-1	WINDOW
	1	D3624-2	BUBBLE WINDOW
1	1	*D3561-1	SEAL INSERT TOOL

* Not part of the -011/-014 installations, tool only